

Work Order ID 76824

76824

Page 1

November-21-11 3:08:39 PM

Item ID: D4450-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 21/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/11/21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4450	A								

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab 1- punch one side
 2- bend as per dwg
 3- drill holes as per dwg
 4- deburr

11/11/23
SB 11/11/23

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

Suluks

120 0.00
120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3
 Powdercoat Memo 0.00
 Powder Coating

NG M-L 11/11/28

M. 11/5/28

17:45
 START TIME: *3200F* FINISH TIME: *2415* OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

November-21-11 3:08:39 PM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	BR	11-11-28	
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							(IX) Sp 11-11-28
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/11/23 JG MF 11-11-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

November-21-11 3:08:44 PM

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Work Order ID: 76824

76824

Parent Item: D4450-1

D4450-1

Parent Item Name: Arm

Start Date: 21/11/2011

Required Date: 05/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.14 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

100

f

287.2801

2.3

2.421053

M304TR0 500W 049

So 11/11/23

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

287.280058

111814

2.23

115010

145.421058

117598

49.87

119087

89.759

2.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

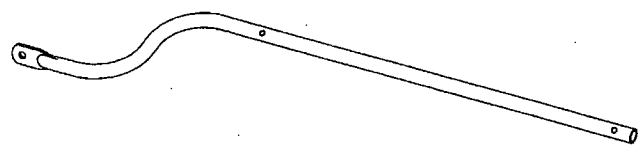
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

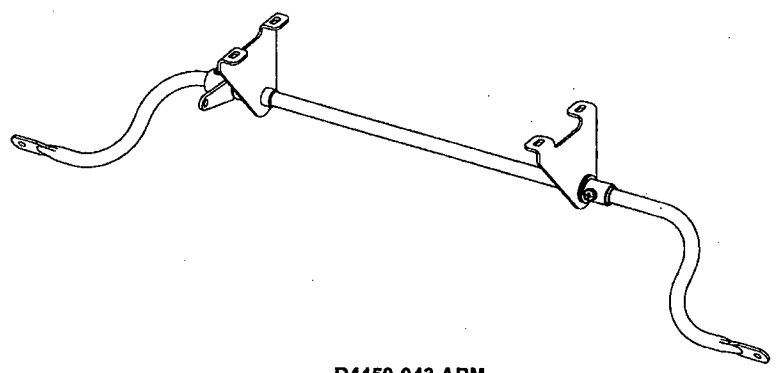
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4450-1 ARM



D4450-043 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76824 M.L.J
11/11/21

RELEASED
2011-11-10

A	NEW ISSUE	DESCRIPTION	MB	11.09.29
REV.			BY	DATE
DESIGN		DART AEROSPACE USA, INC.		
DRAWN		KENT, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4450	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		ARM	NTS	
DATE	11.09.29	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

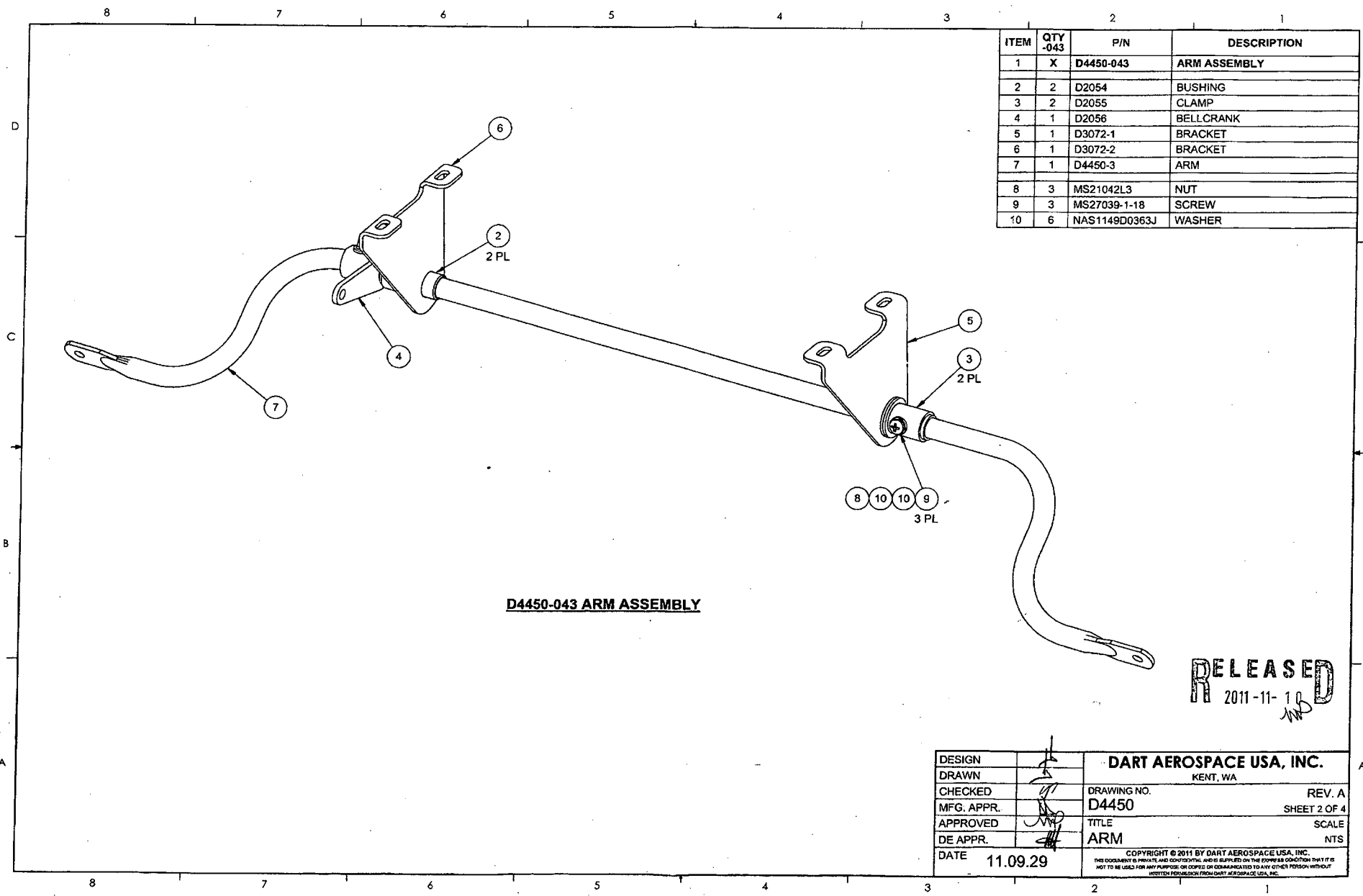
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

76824



D4450-043 ARM ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
1	X	D4450-043	ARM ASSEMBLY
2	2	D2054	BUSHING
3	2	D2055	CLAMP
4	1	D2056	BELL CRANK
5	1	D3072-1	BRACKET
6	1	D3072-2	BRACKET
7	1	D4450-3	ARM
8	3	MS21042L3	NUT
9	3	MS27039-1-18	SCREW
10	6	NAS1149D0363J	WASHER

RELEASED
2011-11-10

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4450	SHEET 2 OF 4
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

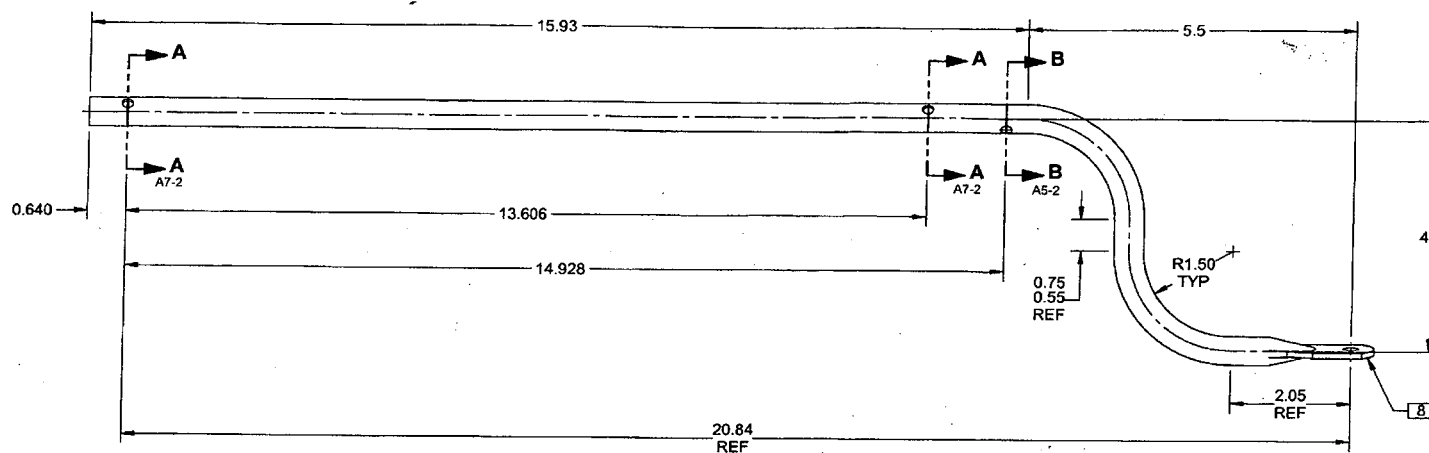
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

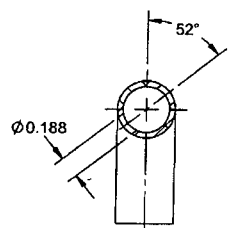
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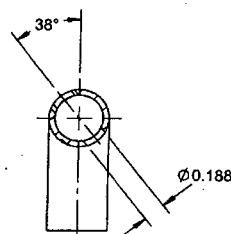
76824



D4450-1 ARM



SECTION A-A
SCALE 2X C4-2
C8-2



SECTION B-B
SCALE 2X C4-2

D4450-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, Ø0.50 X 0.049 WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF. DART SPEC. M304TR0.500W.049
- 2) FINISH: POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) PUNCH END PER SPEC. CONTROL DRAWING D2727

RELEASED
2011-11-18

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4450	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Technical drawing of a cable layout with dimensions and labels. The drawing shows a cable with a central horizontal section and two curved sections at the ends. Dimensions are provided in feet and inches (e.g., 8.2, 13.606, 14.928, 17.92, 29.01 REF, 0.362, 5.5, 4.1 TYP, 2.05 REF, 0.75, 0.55 TYP REF, R1.50 TYP, 78°). Labels include 'C', 'D', 'A7-3', 'A5-3', and '8 TYP'. A scale bar at the top indicates distances from 1 to 8 feet.

D4450-3 NOTES:

- 04450-3 NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, Ø.050 X 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION NONE
 - 7) WEIGHT: 0.72 lbs
 - 8) PUNCH END PER SPEC. CONTROL DRAWING D2727
 - 9) REFER TO SHEET 2, 04450-043 ARM ASSEMBLY, FOR INSTALLATION OF REQUIRED PARTS PRIOR TO PERFORMING ALL BENDS

RELEASE
2011-11-10

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4450	SHEET 4 OF
APPROVED		TITLE	SCALE
DE APPR.		ARM	NT
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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